

Work Order ID 133290

June-01-15 1:48:40 PM

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Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing

Start Date: 6/01/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/05/15 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100 0.00

100

Crosstubes

Crosstubes

Memo

0.00

CUT QTY(3) 6" LONG SECTIONS FROM PAINTED 350 TUBE.
 ATTN: THIS TUBE IS ALREADY PAINTED, SO IT JUST NEEDS TO BE
 PICKED.

FILL IN THE P/N & B/N OF THE PICKED TUBE.

P/N 0350-748-101

B/N 125961

SAD 06/01/15

110

0.00

110

Eng

Engineering

Memo

0.00

ENGINEERING APPROVAL

1 φ DAS
12
9-89
15/1/7

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				1	4		DAS 12 9-89
120		0.00							
Purchasing	Memo								
Purchasing	SEND TO EXOVA FOR GRAVEL TESTING PO <u>28902</u>								

130 QC21- Final Inspection - Work Order Release 0.00
 130 Memo 0.00
 QC Quality Control

RD15-748.01

SEP 15 2015
 120150917
 SH

Linda Lacelle

From: Chris Provencal
Sent: June-01-15 1:26 PM
To: Linda Lacelle
Cc: William Monterroza; Nigel Forbes
Subject: Need Gravel Test Samples

Linda,

Can we have 4 w/o's to create the following. This is for gravel testing at Exova:

W/O #1, Existing process (control)

133290

Cut qty(3) 6" long sections from painted 350 tube. This tube is already painted, so it just needs to be picked. We'll pick the fill in the p/n & b/n of the picked tube.

W/O #2, Stainless w/ Metalok

133291

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Axalta 13205S Aluminum Cleaner per manufacturer's instructions
7. Apply Axalta Metalok 230S Adhesion Promoter per manufacturer's instructions
8. Prime and paint outside of tube per Dart QSI 005 4.2
9. Cut into (3) 6" long sections

W/O #3, Stainless w/ Military wash primer

133292

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.

5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Sherwin Williams DOD-P-15328D per manufacturer's instructions.
7. Prime and paint outside of tube per Dart QSI 005 4.2
8. Cut into (3) 6" long sections

W/O #4, Stainless w/ powder coat

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Powder coat white (4.3.5.2) per Dart QSI 005 4.3
7. Cut into (3) 6" long sections

The D6021 material should be able to be cut from the excess mat'l on the ends of the raw extrusion. I believe there's at least 12" extra material on each tube.

Thanks,
Chris

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